

Work Order ID 55110

January 6, 2010 1:43:27 PM



Page 1

Item ID: D3120-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 1/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 10/01/06 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3120	Rev B

110 0.00



HAAS CNC VERTICAL MACHINING #1

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3120

Prog rev: B

Dwg rev: B

Deburr as required

=> Deburr m-h 10/01/26

LB 10-1-6

fa

(ax)

120 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

LB 10-1-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

⇒ 8/10/12/7

(28)

P12 ⇒

135



Brake NC

Brake NC

Memo

1- deburr if necessary
2-bend as per dwg

0.00

0.00

8 10/02/11

(8)

136



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/12/16

(28)

(-4)

W/O: 55110		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/27	#120	Took Qty x1 for QC inspection removal	S	10/01/27	x1		S 10/01/27

Part No: D3120-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3120-4

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Setup Start



Revision ID:

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Item Name: Cover

Start Date: 1/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-02-17

(8)

/



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *3:50*

☐ OVEN TEMPERATURE:

BL 10-02-22

(8)

/

320 FINISH TIME: *4:20*

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

HL 10-02-23

(8)

/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



Revision ID:

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Item Name: Cover

Start Date: 1/06/10

Start Qty: 4.00



Cust Item ID:

Required Date: 1/11/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Identify as per dwg & Stock Location: 181

0.00

Memo

0.00

Packaging

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

PC 143/10 1 (8)

10/03/02 AS

02 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55110



Parent Item: D3120-4



Parent Item Name: Cover

Start Date: 1/06/10

Required Date: 1/11/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			110	sf	218.0254	1.4589	3.5		
											B 10-1-6	
2024-T3 .032 sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

218.0254316

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

6.6032

110305

97.99

110778

18.0296316

111699

11.3342

113189

69

18147

3

113005

113005

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

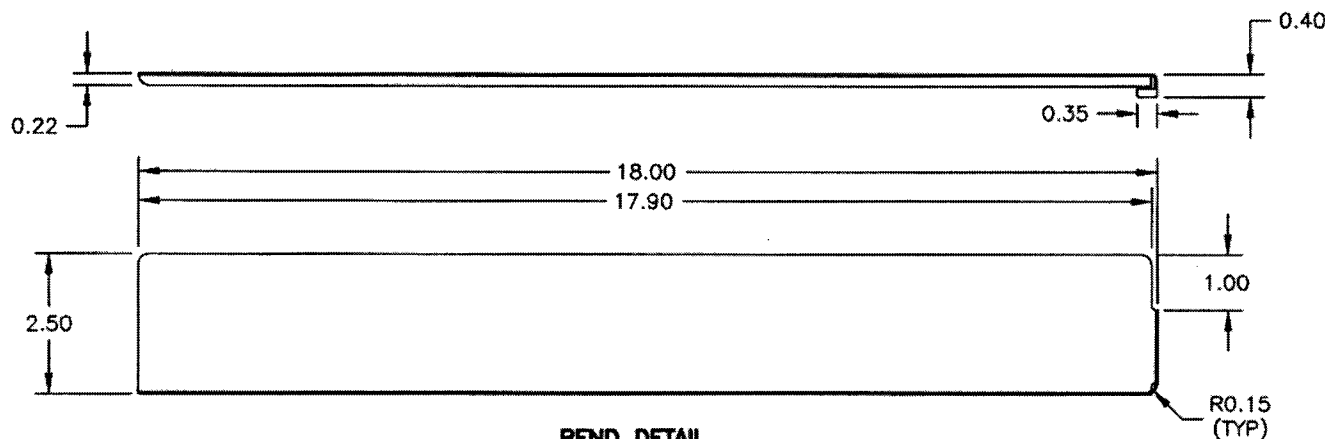
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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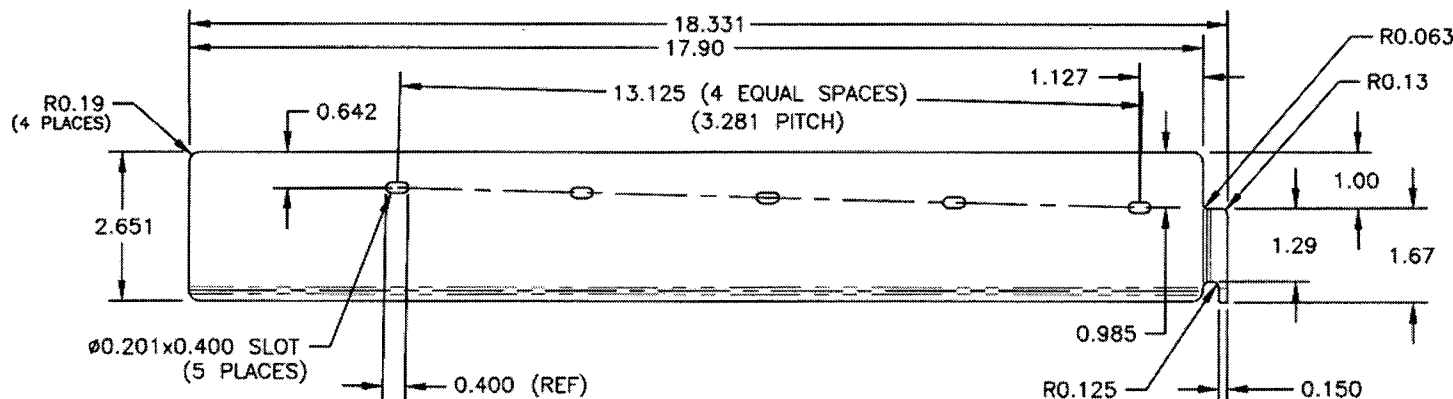


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 04.10.18	TITLE COVER	REV. B
		SHEET 2 OF 2
		SCALE NTS



BEND DETAIL

D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)
D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)



D3120-3/-4 COVER. FLAT PATTERN

D3120-3/-4 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

RELEASED
07/11/13

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